

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024059**Date Inspected:** 16-May-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA Inspector) George Goulet was present during the times noted above for observations relative to the work being performed.

OBG Trial Assembly Area

This QA Inspector randomly observed the following work in progress in the OBG Trial Assembly Area:

SMAW welding of temporary alignment plates located at PCMK OBG 13AW/13BW transverse joint deck plates. Welder was identified as 066673. QC was identified as ZPMC CWI Sha Zhi (QC1). Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was ZPMC QC Shen Jian Bo (QCA1), who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-P-2212-FCM-1 as verbally identified by QCA1.

FCAW welding of weld joints SEG3013U-017, 018 located on PCMK OBG 13AW. Welder was identified as 037705. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA1, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-T-2233-ESAB as verbally identified by QCA1.

SMAW welding of weld joints SEG3013P-128, 137 located on PCMK OBG 13AE. Welder was identified as 066673. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA1, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-P-2213-B-U2-FCM-1 as verbally identified by QCA1.

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SMAW repair welding of weld joint SEG3013K-038 located on PCMK OBG 13AE. Welder was identified as 066674. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA1, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-345-SMAW-3G(3F)-FCM-repair-1 as displayed on ZPMC Weld Repair Report B-CWR2836 as presented to this QA Inspector and verbally identified by QCA1.

SMAW welding of weld joints KP3017-001-002, 004, 006 located on PCMK OBG 13AW. Welders were identified as 067829, 067520. QC was identified as QC. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was ZPMC QC Wang Xiang Pin (QCA2), who was not a CWI. Weld variables recorded by QCA2 appeared to comply with WPS-B-P-2214-TC-U4b-FCM-1 as verbally identified by QCA2.

SMAW welding of weld joints DP3116-001-052, 057 located on PCMK OBG 13AW. Welders were identified as 067725, 066881. QC was identified as QC. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA2, who was not a CWI. Weld variables recorded by QCA2 appeared to comply with WPS-B-P-2214-FCM-1 as verbally identified by QCA2.

SMAW welding of weld joints BP3062-001-003, 005 located on PCMK OBG 13AW. Welder was identified as 066398. QC was identified as QC. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA2, who was not a CWI. Weld variables recorded by QCA2 appeared to comply with WPS-B-P-2212-FCM-1 as verbally identified by QCA2.

SMAW welding of weld joints EP3020-001-069, 070, 073, 074, 077, 078, 081, 082, 085, 086 located on PCMK OBG 13BW at the transverse joint to 13AW. Welder was identified as 066881. QC was identified as QC. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA2, who was not a CWI. Weld variables recorded by QCA2 appeared to comply with WPS-B-P-2114-FCM-1 as verbally identified by QCA2.

SMAW welding of weld joints EP3021-001-001, 002, 009, 010, 017, 018, 025, 026, 033, 034 located on PCMK OBG 13AW at the transverse joint to 13BW. Welder was identified as 066881. QC was identified as QC. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA2, who was not a CWI. Weld variables recorded by QCA2 appeared to comply with WPS-B-P-2114-FCM-1 as verbally identified by QCA2.

FCAW welding of weld joints OBE13K-010 located at PCMK OBG 13BE/13CE transverse joint. Welder was identified as 055564. QC was identified as QC. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA2, who was not a CWI. Weld variables recorded by QCA2 appeared to comply with WPS-B-T-2231-ESAB as verbally identified by QCA2.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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## Summary of Conversations:

As noted above.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey 15000026784, who represents the Office of Structural Materials for your project.

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**Inspected By:** Goulet, George

Quality Assurance Inspector

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**Reviewed By:** Riley, Ken

QA Reviewer